Work Order ID 77316 *77316* Page 1 December-02-11 11:31:57 AM *N900040100* Item ID: D3182-1 Accept Setup Start **Revision ID:** Item Name: Hinge *4* Start Oty: 4.00 **Start Date:** 02/12/2011 **Cust Item ID: Required Date:** 08/12/2011 Req'd Qty: 4.00 **Customer:** Reference: Run Process Plan: M.C.J Date: 1112 02 Tooling: **Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Reject Reject Insp. Accept **Work Center ID** Code Number Stamp Description **Qty Qty Run Hours Draw Nbr Revision Nbr** D3182 Rev A 100 0.00 FLOW WATER JET *100* B11-17-5 Waterjet 0.00 Memo A Prog Rev: 2-FLOW CNC Waterjet 1-Cut as per Dwg D3182 Dwg Rev:___ Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* (B11-17-5 QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check

120

Quality Control

Memo

QC

										
W/O:			W	ORK ORDER CHANG	GES			_		2 - 12 - 12
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCI	R: Yes	No DQ	A :	_ Date: _	
	Res	solution:	Dispositio	n:	QA:	N/C CI	osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	Sign &		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
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Work Ord December-02-1				*773′	16*							Page 2	,
Item ID: Revision ID: Item Name:	D3182-1 Hinge			Accept	*N900	040	100)*	Setup	Start Stop	IV.	S1* S2*	
Start Date: Required Date: Reference:	02/12/2011 08/12/2011	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	-]	Run	Start	*NI	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*NI	R2*	
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr if ne	cessary	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
140 *1 1 1 1 1 1 1 1 1 1 		QC5- Inspect part comple	eteness to step on W/O	0.00 \ A C)								
150 *150*		Identify as per dwg & Sto	ock Location:	0.00			(Cul] [[2],	L	(10	/	
Packaging		Memo		0.00							てフ		

*****STOCK IN BASKET CELL****

Packaging

										
W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PR	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Cate	gory:	NCF	l: Yes	No DQA	\ :	Date:	
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NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR)			
DATE	OTED	Description of NC			ction B		Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	١	Sign & Date	Section		Chief Eng	QC Inspector
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Work Ord December-02-1				*773	316*							Page 3
Item ID: Revision ID: Item Name:	D3182-1 Hinge			Accept	*N900	040	100)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	02/12/2011 08/12/2011	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:						
Approvals:	Process Pla	n:	Date:	Tooling:		ite:			Run	Start Stop	*N	R1*
	QC:		Date:	SPC (Y/N):	Da	ite:				_	×Ν	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Re Qt	•	Reject Number	Insp. Stamp
*160 *160* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00							12	13 4

MC 11-12-13

W/O:			V	ORK ORDER CHANC	GES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC	t. tat - 1		tion B	Sign &		cation	Approval	Approval
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Picklist Print

December-02-11 11:32:01 AM

Work Order ID: 77316

77316

Parent Item:

D3182-1

D3182-1

Parent Item Name: Hinge

Start Date: 02/12/2011

Required Date: 08/12/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A03.01.29New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	68.4000	0.0596	0.250947	(,		
M304S1-1	I-GA								**	H3	(1-13-	5	

Location	Loc Qty	Loc Code	
MAT020	68.4		
119006	32.5		
119048	35.9		119048



W/O:	<u> </u>		W	ORK ORDER CHANG	ES			
DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							Prod Mgr	
		•						
Part No		PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA :	Date: _	
		esolution:						
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	3)		
		Description of NC		Corrective Action Secti	on B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	77316
Description: Hinge	Part Number:	D3182-1
Inspection Dwg: D3182 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.718	+/-0.010	3,700	2		L 1362	
Ø0.257	+0.006/-0.001	-761	X		V	
2.304	+/-0.010	2.309	7		V	
R0.125	+/-0.010	7(1)	>		R.G.	
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: (1-17-5	Date: 11/12/0	Date:	N/A

A 06.10.12 New Issue KJ/JLM B 08.01.16 3.718 was 3.178 K VEC/DD - X	Rev	Date	Change	Revised by	Approved
B 08 01 16 3 718 was 3 178	Α	06.10.12	New Issue	KJ/JLM	
La colori to cirio mas oli to	В	08.01.16	3.718 was 3.178	KJ/EC/DD	787

Dart Aerospace L	td	_tc	L	e	C	a	D	S	ď	er	Α	rt	Da	1
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W/O:			14/	ORK ORDER CHANG	EC					
DATE	STEP	PROCEDURE CHANGE				y	Date Q		Approval QC Inspector	
								Prod Mgr	QO IIISpecioi	
									 	
									<u></u>	
Part No:		PAR #:	Fault Cate	egory:	_ NCR: \	es N	lo DQA: _	Date: _		
	Re	esolution:	on: Disposition:							
NCR:			WORK ORE	ER NON-CONFORMA	ANCE (N	ICR)	-			
					tion B		Verification	n Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & Date	Section C		QC Inspector	
:										

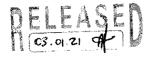


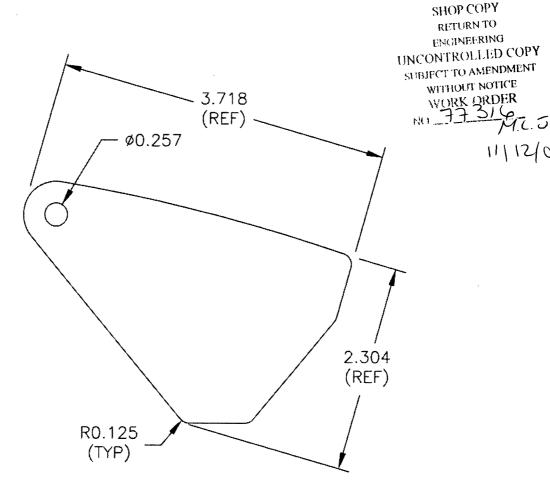


)	DESIGN	DRAWN BY	1	AEROSPACE LT	D
	CHECKED	APPROVED	DRAWING NO.		REV. A
	#	- H	D3182	SH	IEET 1 OF 1
	DATE		TITLE		SCALE
	03.01.21		HINGE		1:1
	A	03.01.21	NEW ISSUE		

RETURN TO

11/12/02





D3182-1 HINGE

- 1) MACHINE D3182-1 PER DART DWG "D3182-1.DWG"
- 2) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK (REF DART SPEC. M304S11GA)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:	<u> </u>		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:										
	Re			Disposition: QA: N/C Closed: Date:								
NCR:		\	WORK OR	DER NON-CONFORMA	NCE (NCR))	•					
DATE	STED	Description of NC Section A		Corrective Action Section		Verificatio		Approval				
DAIL	SILF		Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector				
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